Work Order ID 106118 *106118* Page 1 August-28-13 1:10:25 PM D3933-2 Accept *N900040100* Setup Start Item ID: **Revision ID:** Aft Wall Protector, RH Item Name: **Start Date:** 8/23/13 Start Qtv: 3.00 **Cust Item ID:** Req'd Qty: 2.00 Required Date: 8/28/13 **Customer:** Reference: Run Date: 13-08-29 Tooling: Process Plan: MUS Approvals: Date: Stop SPC (Y/N): QC: Date: Date: Sequence ID/ Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Operation Work Center ID Description Code Qty Qty Number Stamp **Run Hours Draw Nbr Revision Nbr** D3933 Α 0.00 100 *100* 0.00 Waterjet Memo 1-Cut as per Dwg D3933 FLOW CNC Waterjet Dwg Rev: 🔭 Prog Rev: A 2- Deburr if necessary

0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

110

QC

110

Quality Control

| | | | | | | | | | • | DQA | .:บ | ate: _ | | |
|---------------|------------|------------|-------------------|--------|----------------------------|------------|-------------------------------|-------------------------|-----------|-------------|---------------|--------|--------------------|--|
| NCR: | res / N | 0 | | | WORK ORDER NON-O | COI | NFOR! | MANCE / UP | DATE | QA Closed | | ate: | | |
| | | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | |
| Work Orde | er: | | | | | | AGAIIVSI DEPARTIVIENT/PROCESS | | | | | | | |
| | | | | | Rework | | | Skid-tube | Crosstube | | Water Je | - | Engineering | |
| Part N | ۸o | | | | Scrap | | | Machining | Small Fab | | od. Eng. Coor | - | Quality | |
| NO. N | | | | | Use-as-is | 4 | 1 | noforming | Finishing | Rec/Sto | ore/Packaging | _ | Other | |
| NCR No. | | | Work Order Update | J | | Large Fab. | Composite | _ | Supplie | r | | | | |
| Root | | | | Descri | ption of work order update | | Initial | Act | tion | Sign & | | | | |
| Cause | Dat | e Step | Qty | (| or Non-conformance | Ch | nief Eng | Desc | ription | Date | Verification | on | QC Inspector | |
| Doc/Data | | | | | | | | | | | | | | |
| Equip/Tooling | | | 1 | | | | | 3 | | | | | | |
| Operator | Ш | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | |
| Setup | | | | İ | | | | | , | Ì | |] | | |
| Other | | | | | | | | | | | 1 |] | | |
| Process | | | | | | 1 | | | | | | i | | |
| Supplier | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | |
| | | | | | F | AUI | T CATE | GORY | | | | | | |
| Landi | ng Gear | | | | General | | _ | | | _ | | _ | | |
| | Bendi | ng | | | Bend | | Grain | | | Ovalized | | | Pressure/Forced | |
| | Centr | Not Conce | entric to | O/S | BOM/Route | | Hardwa | re | | Over/Unde | r tolerance | | Temperature/Cure | |
| | Crack | 5 | | | Broken/Damaged | | Inspecti | on Incomplete | | Part Incorr | ect | | Weld | |
| | Crush | ed/Crimped | i | | Burrs | | Instruct | ions Incomplete/Unclear | | Part Lost/N | /lissing | | Wrong Stock Pulled | |
| | Cuffs | | | | Contamination | | Mainte | ntenance Pa | | | Part Moved | | | |
| | Heat Treat | | | | Countersink | | Mislabeled | | | Positioned | Wrong | | | |

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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| Work Orde | | 6118 | | *106 | | Page 2 | | | |
|--|---------------------------|---|----------------------|---------------------|---------------------------|---------------------|---------------|--------------------------|------------------------------|
| Item ID: Revision ID: Item Name: | D3933-2 Aft Wall Prote | ector, RH | | Accept | *N9000 | 140100 |)* s | etup Start Stop | *NS1* *NS2* |
| Start Date: Required Date: Reference: | 8/23/13 | Start Qty: 2.00 Req'd Qty: 2.00 | *2* *2* | | Cust Item ID Customer: | : | | | 14()/ |
| Approvals: | | an: | Date: | Tooling: SPC (Y/N): | | e: | R | un Start Stop | *NR1* *NR2* |
| Sequence ID/ Work Center II 120 *170* QC Quality Control | D | Operation Description QC8- Inspect parts - seco | and check | 0.00 | Tool ID AS 27 389 | Tool # Plan Code | Accept Qty | | Reject Insp. Number Stamp |
| *130 *130* Packaging Packaging | | Identify as per dwg & St Memo | ock Location: PPP | 0.00 | | | _4× | DAS 28 / 9-89 | 3-10-25 |
| 140 *1 40 * QC | | QC21- Final Inspection Memo | - Work Order Release | 0.00 | | | 4× | /3/ DAS 28 9-89 | 13-10-25 |

Quality Control

pl 3-10-25

| | | | | | | | | | | | DQ | 4: Da | ate: | | |
|---------------|---|--------------------------|----------|-----------|-----------------------|----------------------------|----------------------------|-----------|------------------|---------------|-------------|----------------|----------|--------------------|--|
| NCR: | Yes | / No | | | | WORK ORDER NON- | COI | NFORM | | | | - | | | |
| | | | | | | | | | | | QA Close | d: Da | ate: | | |
| Work Ord | or. | | | | | DISPOSITION | AGAINST DEPARTMENT/PROCESS | | | | | | | | |
| WOIR OIG | ÇI., | | | | | Rework | | | Skid-tube | Crosstube | 1 ' | Water Jet | | Engineering | |
| Part I | Vo. | | | | | Scrap | 1 | | Machining | Small Fab | Pı | rod. Eng. Coor | \vdash | Quality | |
| | | | | Use-as-is | 7 | | noforming | Finishing | = | ore/Packaging | - | Other | | | |
| NCR I | Vo. | | | | | Work Order Update |] | | Large Fab | Composite | | Supplier | Γ | | |
| | | | | | | | | | | | | | | | |
| Root | | | | | | ption of work order update | 1 | Initial | | tion | Sign & | | | | |
| Cause | | Date | Step | Qty | ty or Non-conformance | | Ct | nief Eng | Desc | ription | Date | Verification | on | QC Inspector | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | | | 1 | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | İ | | |
| Setup | ட | | | | | | | | | | | | | | |
| Other | $ldsymbol{le}}}}}}$ | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | İ | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | |
| | | | | | | | FAUI | LT CATE | GORY | | | | | | |
| Landi | _ | 1 | | | | General | _ | 7 | | | 7 | | | | |
| | L | Bending | | | | Bend | \perp | Grain | | <u> </u> | Ovalized | | Ш | Pressure/Forced | |
| | <u>_</u> | Centre N | ot Conce | ntric to | o/s | BOM/Route | L | Hardwa | re | | Over/Und | er tolerance | | Temperature/Cure | |
| | _ | Cracks | | | | Broken/Damaged | | 4 ' | on incomplete | | Part Incor | | \vdash | Weld | |
| | $ldsymbol{le}}}}}}$ | Crushed/ | Crimped | | <u> </u> | Burrs | <u> </u> | Instruct | ions Incomplete/ | 'Unclear | Part Lost/i | - | Ш | Wrong Stock Pulled | |
| | | Cuffs | | | | Contamination | L | Mainte | enance | _ | Part Move | | | | |
| | | Heat Tre | at | | | Countersink | | Mislabe | eled | | Positioned | l Wrong | | | |
| 1 | 1 | Inspection Strip in Tube | | | | Cut Too Short | 1 | Misread | i | Power Los | s/Surge | | Other | | |

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short Drill Holes

Drawing

Finish

Folio

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Picklist Print

August-28-13 1:10:24 PM

Work Order ID:

106118

Parent Item:

D3933-2

Parent Item Name:

Aft Wall Protector, RH

Start Date: 8/23/13

Required Date: 8/28/13

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------------------|--------------|---------------|----------------|---------------|
| MLEXS.125-F60029-04 | HECT | Purchased | No | | | 100 | sf | 2,471.4520 | 7.01 | _16,494118 | | 4. | 2.10.50 |
| GE PLASTICS LEXAN S | HEEI | | | Location | | Loc Qty | Lo | c Code | (100g-100 - 100g-1 - 11 | | ············ | W1- | 31-1-V# |
| | | | | MAT018 | | 2471.452 | | | | | | | |
| | | | | 12486 | 6 | 286.792 | | | | | | | • > |
| | | | | m126- | 425 | 2184.66 | | | 12 | 6425 - | > ∶ | 33,C | \mathcal{O} |

| NCR: | · | | | | | | | | | | | | | | |
|---|---|-----------|------------|---|-----|--|-----|----------------------------|--|-----------------------|--|--------------|--------------|--|--|
| | | | | | | | | | | | QA Closed: | Date | • | | |
| Work Orde | er: _ | | _ | | | DISPOSITION | _ | AGAINST DEPARTMENT/PROCESS | | | | | | | |
| Part No | | | | | | Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite | | | Small Fab Finishing | Pro Rec/Sto | Engineering Quality Other | | | | |
| Root | | | | | | iption of work order update | | Initial | Act | | Sign & | | | | |
| Cause | . | Date | Step | Qty | (| or Non-conformance | Cl | nief Eng | Descr | iption | Date | Verification | QC Inspector | | |
| Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved | | | | | | | FAU | LT CATE | GORY | | | | | | |
| Landi | ing G | Gear | | | | General | | | | | | | | | |
| | Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend | | | Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes | | Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset | | | Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V | ct issing Vrong | Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other | | | | |
| 1 | ļ | iTorque V | Vaves in I | Extrusio | n I | Drawing | - 1 | Out of (| Calibration | | | | | | |

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

| DART AEROSPACE LTD | Work Order: | 106118 |
|---|--------------|-------------|
| Description: Aft Cabin Wall Protector, RH | Part Number: | D3933-2 |
| Inspection Dwg: D3933 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| | X | First Artic | :le | Proto | type |
|----------------------|-----------|---------------------|--------|--------|---------------------------------------|
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method Inspecti |
| 0.88 | +/-0.030 | . XX " | _ | | \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ |

| Drawing | Tolerance | Actual | Accept | Reject | Method of Inspection | Comments |
|-----------|-----------|--------------|--------|--------|-------------------------|----------|
| Dimension | | Dimension | | | | |
| 0.88 | +/-0.030 | ,88" | | | | JKM-01 |
| 19.00 | +/-0.030 | i9.00° | - | | T | UKM-06 |
| 26.75 | +/-0.030 | 26.75" | _ | | T | |
| 27.38 | +/-0.030 | 27.38" | _ | | T | |
| 34.75 | +/-0.030 | 34.75" | | | T | |
| 31.50 | +/-0.030 | 31.50" | | | T | |
| 25.79 | +/-0.030 | 25.79" | - | | T | |
| 0.125 | +/-0.010 | .126" | _ | | | |
| 23.25 | +/-0.030 | 23.25" | _ | | Τ | · |
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| Meas | ured by: | A | Audited by: |)AS | Prototype Approval: | N/A |
|------|----------|-----------|-------------|--------|---------------------|----------|
| | Date: | 13-10-24 | Date: | 9-89 | Date: | N/A |
| Rev | Date | Change | | 131025 | Revised by | Approved |
| A | 09.06.22 | New Issue | | | KJ 🖖 | |



